

Work Order ID 62977

Thursday, October 14, 2010 12:58:34 PM



Page 1

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4064	A

100



Waterjet

FLOW CNC Waterjet

6061 750X 6"

Memo

0.00

AB10-10-26
AB10-11-23 21

20

Cut as per Dwg
DWG REV: A
PROG REV: A

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

AB10-10-6

AB10-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62977

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Mill Conv

Conventional Milling Machine

Memo

0.00

AS 10/11/08

AS 10/11/25 19

PTO →

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

AS 10/11/09

AS 10/11/25 19

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 10/11/09

AS 10/11/25

20 4

18 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty.	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 4064-041 PAR #: (1) Fault Category: Machined parts small fab w-Jet- NCR: Yes No DQA: Date: 10/11/26
 Resolution: Scrap / Scrap Disposition: Scrap / Scrap QA: N/C Closed: Date: 10/12/01

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
(1) <u>10/11/25</u>	<u>130</u>	<u>Lug rotated in vise while cutting rad, QTY 2 SCRAPPED.</u> <u>parts</u> <u>R.C. process</u>	<u>10/11/25</u>	<u>- Scrap & Destroy.</u> <u>- parts were being machined on a manual mill.</u>	<u>10/11/25</u>	<u>8</u> <u>10/11/25</u>	<u>10/11/25</u>	<u>10/11/25</u>
(2) <u>10/11/26</u>	<u>130</u>	<u>Lug dimension .306 is off on one side actual .285.</u> <u>R.C. process</u>	<u>10/11/26</u>	<u>Taper due to cutting on the water jet.</u>	<u>10/11/26</u>	<u>8</u> <u>10/11/26</u>	<u>10/11/26</u>	<u>10/11/26</u>

NOTE: Date & initial all entries

Work Order ID 62977

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
Number
Insp.
Stamp

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

2) M

10/11/29

18

~~10/11/29~~

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115291. START: 11:35
Memo OVEN. 320° 0.00
FINISH 12:05.

(2) M115291

20 10-11-10.

START. 1:45 OVEN. 320° FINISH 2:15.

(18) 10-11-29.

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

2) M 10/11/20

20 Q

2) M 10/11/29

18 Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



HandFinish

Hand Finishing

Memo

0.00

0.00

0.00

0.00

0.00

0.00

0.00

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S10W130

2018

210



Packaging

Packaging

Identify as per dwg & Stock Location: 462

0.00

0.00

Memo

10/12/11 SP 12a

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4064-041 PAR #: _____ Fault Category: Small Frb. - W-Jet NCR: Yes No DQA: ✓ Date: 10/12/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 10/12/06

NCR: 62977		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/06 190		Finish looks is unacceptable rough. parts should have been deburred properly! Reprocess	10/11/06	disassemble - deburr properly to a smooth finish M112567 re powder coat	10/12/06 N/S	✓ N/S	Fault 15 10/12/06	✓ 10/12/06
10/11/06 190		Found Befur parts were ground that others have variance between Dim .241 + .307 due to the taper of w/J.	10/11/06	Buffing parts results in D1145 0.306 and 0.241 below acceptable tolerance. Scrap. QTY 70	10/12/06	✓ 10/12/06	✓ 10/12/06	✓ 10/12/06
		Pl. water set tape + not caught on inspection work	10/11/06	Rep/ree M112567 +20 pcs.	10/11/06 10/11/06	✓ 10/11/06	✓ 10/11/06	✓ 10/11/06

NOTE: Date & initial all entries

Work Order ID 62977

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Revision ID:

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Stop



Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 14, 2010 12:58:38 PM

Page 1

Work Order ID: 62977



Parent Item: D4064-041



Parent Item Name: Mounting Lug

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-03-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased		No		100	f	38.0800	0.35	7.368421		10-11-23 10-10-26	21

6061T6 BAR .750 X 6.00

MS35489-93



GROMMET

Purchased

No

Location	Loc Qty	Loc Code
MAT03	38.08	
112567	38.08	

190 Each 68.0000

2 40

112567

20

Location	Loc Qty	Loc Code
ST296	68	
115816	68	

68
68

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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62977
Description: Mounting Lug	Part Number:	D4064-041
Inspection Dwg: 74064, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	10/11/25	Date:	10/11/26	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	11977
Description: Lug	Part Number:	D4064-1
Inspection Dwg: D4064	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by:		Preliminary Approval:	N/A
Date:	10/11/09	Date:	10/11/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.08.04	Dimensions updated	KJ	✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

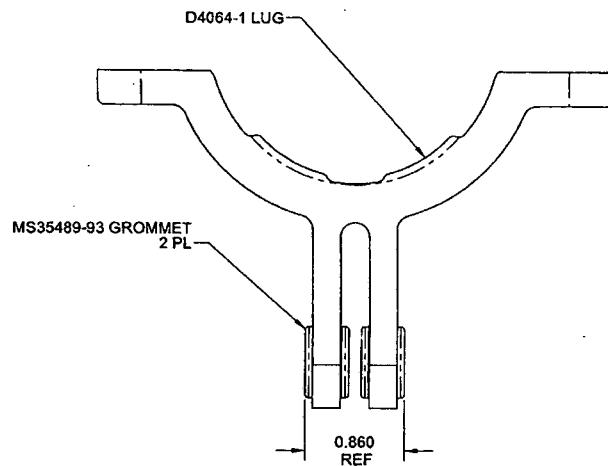
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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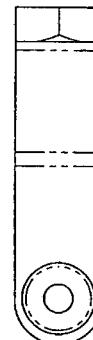
NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D4064-041	LUG ASSEMBLY
2	1	D4064-1	LUG
3	2	MS35489-93	GROMMET



D4064-041 LUG

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.18 lbs



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY

NO. 02977
 BY 10-10-14

RELEASED
 2010-03-01

A	NEW ISSUE		CP	10.01.25
REV.	DESCRIPTION		BY	DATE
DESIGN	93	DART AEROSPACE USA, INC.		
DRAWN	93	PORT HADLOCK, WA		
CHECKED	10	DRAWING NO.	REV. A	
MFG. APPR.	CE	D4064	SHEET 1 OF 2	
APPROVED	SH	TITLE	SCALE	
DE APPR.	SH	CLAMP	NTS	
DATE	10.01.25	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR OTHER PURPOSES, OR OTHERWISE DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

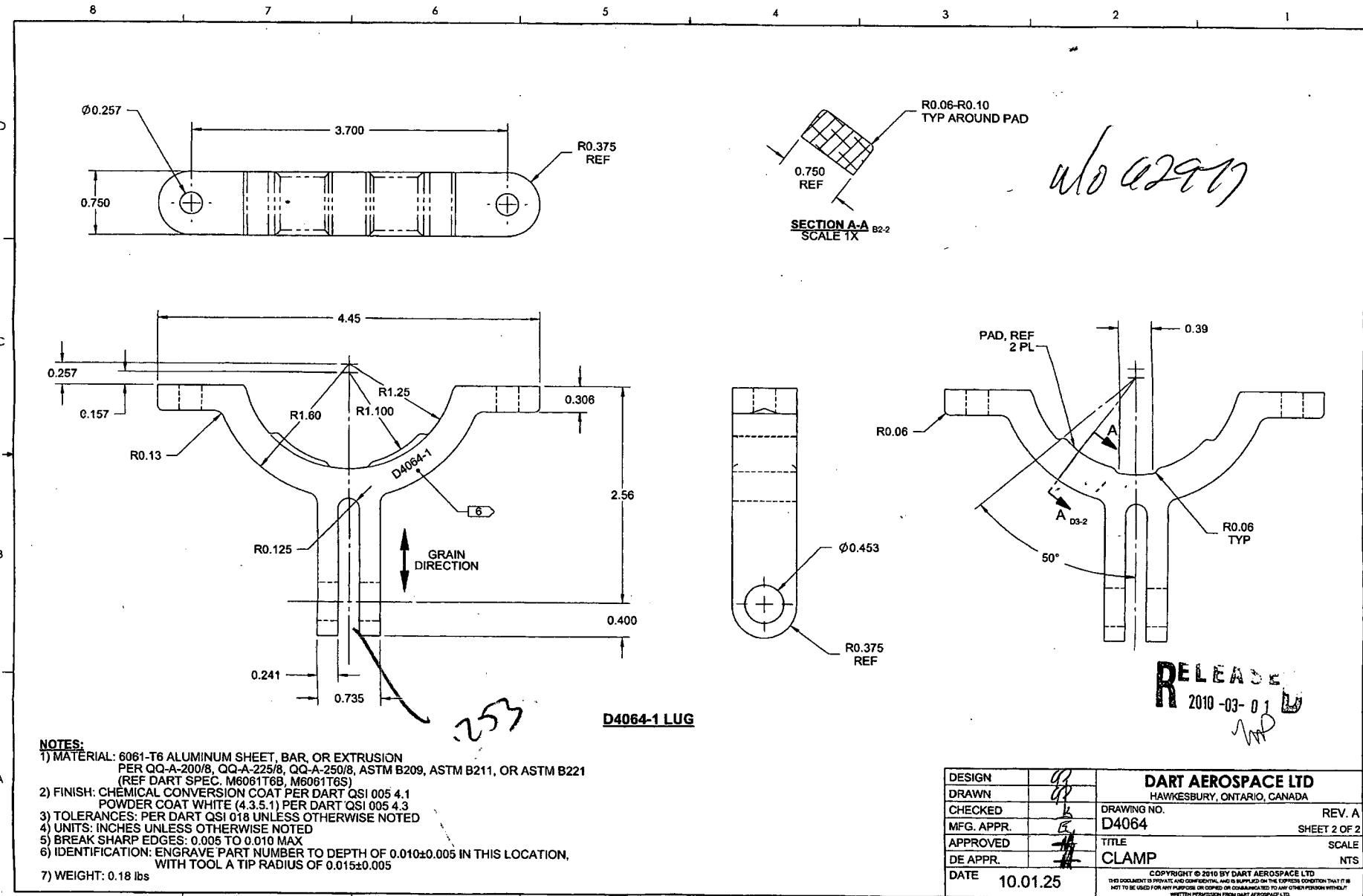
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>99</i>	DART AEROSPACE LTD
DRAWN	<i>99</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1</i>	DRAWING NO.
MFG. APPR.	<i>1</i>	D4064
APPROVED	<i>1</i>	REV. A
DE APPR.	<i>1</i>	SHEET 2 OF 2
DATE	10.01.25	TITLE
		CLAMP
		SCALE
		NTS

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